

Date: Monday, 16/06/2008 10:25:27 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number :	39888		
Estimate Number :	10833		
P.O. Number :		Part Number :	D29331
This Issue :	16/06/2008	Drawing Number :	D2933 REV C
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	11	Drawing Revision :	C
Previous Run :	37866	Material :	
Written By :		Due Date :	04/07/2008
Checked & Approved By :	JUD 08.6.16	Qty:	6 Um: Each
Comment :	Est: B00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101001

Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x .625 X 6.00

Grain Along Long 6.00 Length

Batch No: B 34872

DIP 08/07/03

6

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

5-Deburr

28 05/07/03

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

28 08/07/03

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

28 08/07/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 16/06/2008 10:25:27 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 39888

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/07/03

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/07/04

(6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

7:40

OVEN TEMPERATURE:

320

FINISH TIME:

8:10

FL 08/07/07

(6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08-07-07

(6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

408A

8/7/7

(4)

SL

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/08

Job Completion



4 08-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39888
Description: 206 Saddle, Inboard, Left side		Part Number: D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.123	.123	.122	.122	
B	0.100	0.140		.119	.119	.119	.119	
C	0.100	0.140		.134	.134	.120	.120	
D	0.210	0.230		.219	.219	.220	.221	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.500	.500	.510	.510	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.259	.259	.259	.259	
L	0.312	0.317		.313	.313	.313	.313	
M	0.235	0.240		.238	.238	.238	.238	
N	0.100	0.140		.121	.121	.121	.121	
O	0.540	0.560		.540	.540	.548	.550	
P	0.490	0.510		.500	.500	.510	.510	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.504	2.504	2.500	2.500	
S	0.240	0.270		.260	.250	.255	.255	
T	0.100	0.180		.135	.135	.135	.135	
U	1.625	1.635		1.627	1.627	1.627	1.627	
V	1.362	1.372		1.370	1.370	1.370	1.370	
W	0.316	0.321		.320	.320	.320	.320	
X	1.125	1.145		1.131	1.131	1.131	1.130	
Y	1.565	1.585		1.570	1.570	1.570	1.570	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: [Signature]	Date: 08/07/03
Audited by: J.L. 08/07/03	Date:
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD [Signature]	[Signature]

DART AEROSPACE LTD				Work Order: 39808	
Description: 206 Saddle, Inboard, Left side				Part Number: D2933-1	
Inspection Dwg: D2933 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.120	.120			
B	0.100	0.140		.117	.117			
C	0.100	0.140		.119	.119			
D	0.210	0.230		.221	.220			
E	1.245	1.255		1.250	1.250			
F	1.245	1.255		1.250	1.250			
G	2.495	2.505		2.500	2.500			
H	0.510	0.515		.510	.510			
I	1.572	1.582		1.577	1.577			
J	2.495	2.505		2.500	2.500			
K	0.257	0.262		.259	.259			
L	0.312	0.317		.313	.313			
M	0.235	0.240		.238	.238			
N	0.100	0.140		.121	.121			
O	0.540	0.560		.550	.550			
P	0.490	0.510		.510	.510			
Q	3.715	3.725		3.720	3.720			
R	2.470	2.510		2.500	2.500			
S	0.240	0.270		.250	.250			
T	0.100	0.180		.135	.135			
U	1.625	1.635		1.628	1.628			
V	1.362	1.372		1.370	1.370			
W	0.316	0.321		.320	.320			
X	1.125	1.145		1.130	1.131			
Y	1.565	1.585		1.572	1.571			
Z	0.178	0.198		.188	.188			
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: JS	Date: 04/07/03
Audited by: J.L	Date: 08/07/03
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	



D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)

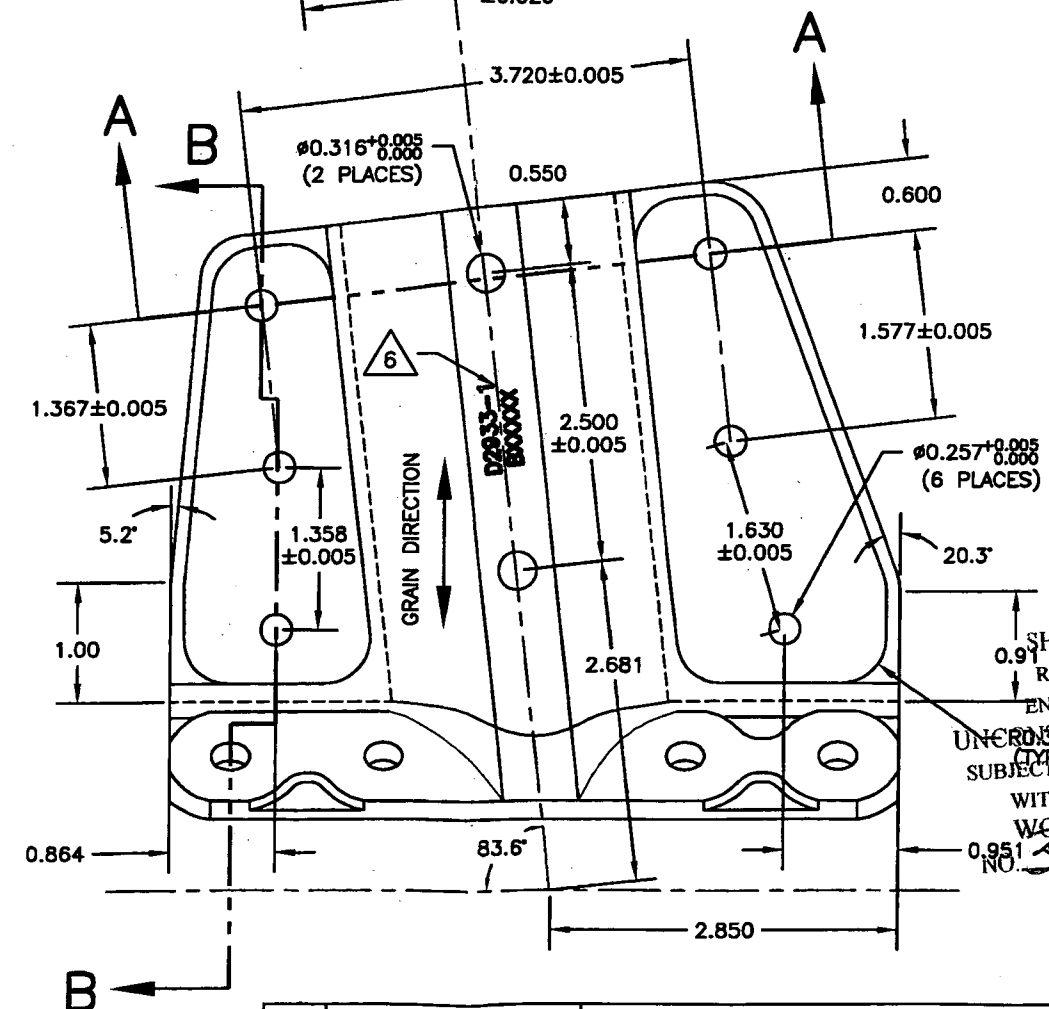
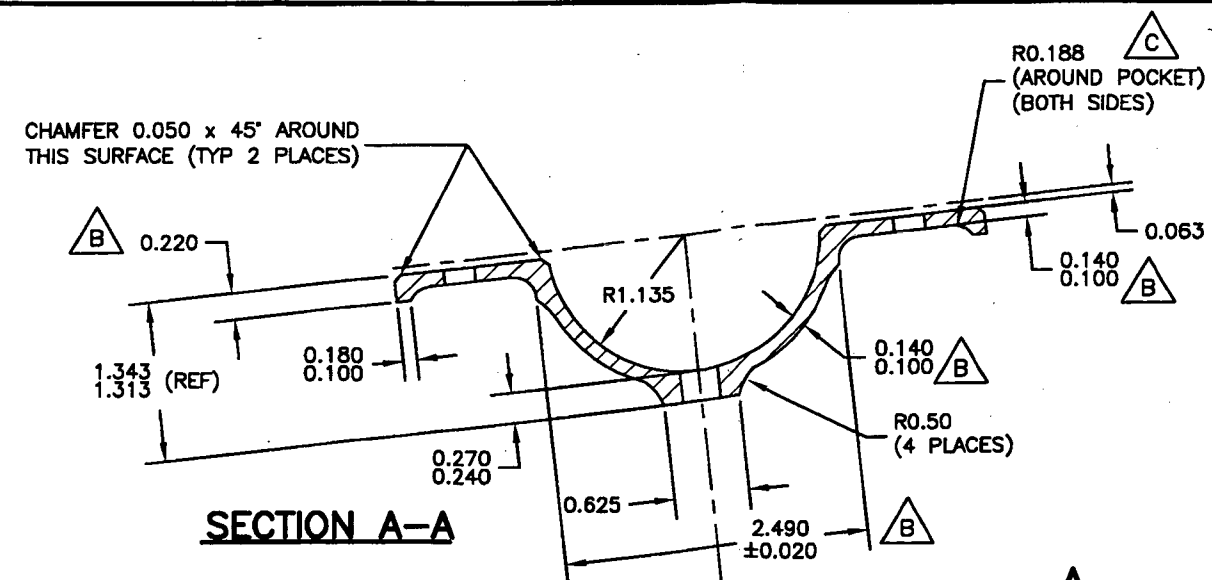
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3


3) BREAK ALL SHARP EDGES 0.010 TO 0.020

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

5) ALL DIMENSIONS ARE IN INCHES

6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



DESIGN	<i>A</i>	DRAWN BY	<i>CB</i>	 DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	<i>PH</i>	APPROVED	<i>A</i>	
DATE		DRAWING NO.		REV.
06.11.09		D2933		SHEET 1 OF
TITLE		SCALE		
SADDLE INSIDE		2:		

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DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
BELLEVUE, WA

DRAWING NO.	REV.
D2933	SHEET 1 OF

TITLE	SCALE
SADDLE INSIDE	2:

0.91

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(TYPE)

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

0.951

NO. 51888

RELEASED

07.02.12